

Date: Friday, 16/05/2008 7:45:50 AM
User: Linda Lacelle

23/05

Dart Aerospace Ltd.

Split

SD 08/05/21

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPLATE
Job Number	: 39312 ~1	Part Number	: D33191
Estimate Number	: 10437	Drawing Number	: D3319 REV. B
P.O. Number	:	Project Number	: N/A
This Issue	: 16/05/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: / /	Due Date	: 23/05/2008
Previous Run	: 38646	Qty:	12 Um: Eac
Written By	:		
Checked & Approved By	:		
Comment	: Est: B 05.10.14 Added step 9, dwg rev B KJ/EC Est Rev:C Now on Waterjet 06-10-26 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025/A21/6aA SHEET .048 16
		Comment: Qty.: 0.6594 sf(s)/Unit Total : 7.9128 sf(s) 1010/1025/A21/6aA SHEET .048 Batch: 106603 B 8-5-20
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: B B 8-5-20 Prog Rev: 8-5-20
		2-Deburr if necessary B 8-5-20
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE B 8-5-20
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK 08/05/21(+)18
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary Done at step # 2.2. 08/05/21

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Seq. #: Machine Or Operation:

Description :

6.0 BRAKE NC NC BRAKE



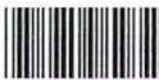
Comment: NC BRAKE

1- Form using DT8326 & DT8261 as per Dwg D3319 Rev: A

2- Form flat on press using DT8776 block

SB 07/05/21 (3)

7.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1- Layout weld location as per Dwg D3319 using jig D3319-1T3

2- Weld hard surface using D3319-1T2 per QSI 004 and Dwg D3319 Rev: _____

(3x)

Qty Part Number Description Batch
A/R N/A 7560 Hardcoat Rod M106762.

08-05-20. 88

9.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 08/05/21

(x3)

10.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S

08/05/21

(x3)

11.0 POWDER COATING POWDER COATING



M105642

(3x)

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 1:45 pm

OVEN TEMPERATURE: 320°F

FINISH TIME: 2:15 pm

M-1

08/05/21

(3)

12.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FOL

08/05/21

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Job Number:



Seq. #: Machine Or Operation:

13.0 PACKAGING 1



Description :

PACKAGING RESOURCE #1



3X

Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

P/N: D3319-1, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: ST 496

8/5/21

SP

14.0 QC21

FINAL INSPECTION/W/O RELEASE



08/05/21 JJ

Comment: FINAL INSPECTION/W/O RELEASE

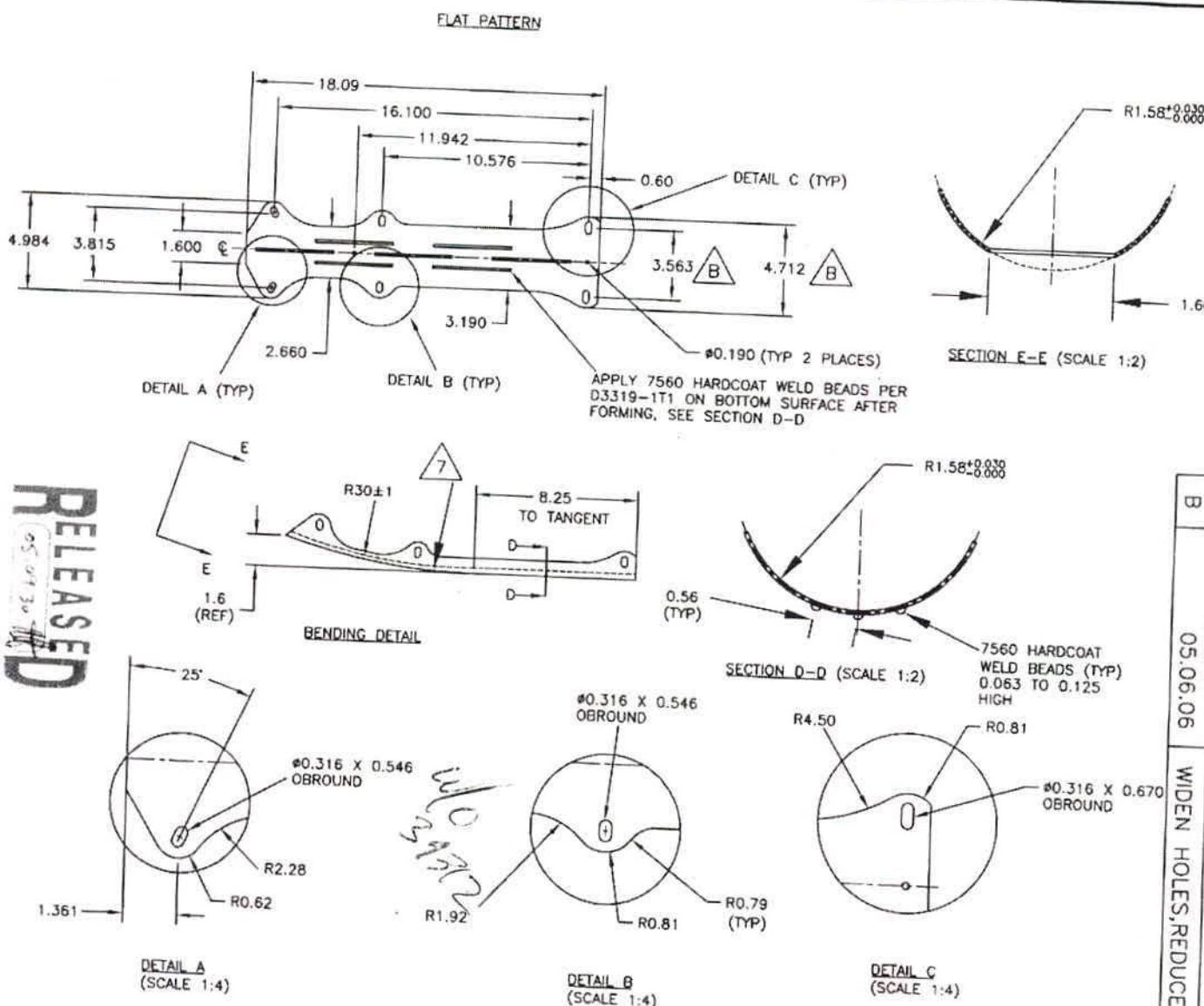
Job Completion



UMF 08-05-21

DART

DESIGN P1	DRAWN BY PH	DART AEROSPACE LTD		
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA		
DATE 05.06.06	DRAWING NO. D3319	REV. B		
TITLE SECTION E-E (SCALE 1:2)	SCALE 1:8	SHEET 1 OF 5		
A B	04.09.24 05.06.06	WEARPLATE WIDEN HOLES, REDUCE WIDTH -3/-5/-7		



Q3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:

"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
05.06.06

JART AEROSPACE LTD

Work Order: 39312

Description: WEAR PLATE

Part Number: D339-1

Inspection Dwg: D-3219-1 Rev: B

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article

Prototype

Measured by: 12

12

Audited by:

Prototypes Approved

Dates

19

Page 1

MOVARI

1

Rev	Date	Change	Revised by	Approved
A		New Issue	K.I.III M	